

Date: Wednesday, 1/11/2006 4:18:05 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350/212/130 BASKET LID
Job Number	: 25438B		
Estimate Number	: 10193		
P.O. Number	: N/A	Part Number	: D2512
This Issue	: 1/11/2006 S.O. No. : N/A	Drawing Number	: D2512 REV D4 D2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: D4 D2
Previous Run	: 25436B	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 1/26/2006
Checked & Approved By	: <u>SEE ABOVE USER & DATE</u>	Qty:	1 Um: Each
Comment	: Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/ RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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Comment: Qty.: 30.4931 f(s)/Unit Total : 30.4931 f(s)

Pick:

3/4"x3/4" 304/316 SS tube .063" wall

Batch: M100023

AA 06/02/13

2.0	D31663	Basket Hoop
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D3166-3 Basket Hoop

Batch

B25508

AA 06/02/13

3.0	D2506	Placard
-----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2506 Label Plate

Batch

B24875

AA 06/02/20

4.0	D23271	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

2 D2327-1 Bushing

Batch

B24873

AA 06/02/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:18:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 25438B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-1

Hinge plate

B23445

AA 06/02/20

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B25139

AA 06/02/20

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

18 sf M304EX0.75-16F Expanded Metal

M100071

AA 06/02/20

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

4-D2012-117 is included in D3172-041 EC130 Basket Base BOM.
EC130 Basket only

Pick:

Qty Part Number

Description

Batch

2 D2012-117 Clevis

AA 06/02/20

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 06/03/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:18:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 25438B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

DD 06-02-20

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

ml 06 03 02

①

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

SPRAY 19640

Batch: m10037

ml 06 03 03 ①

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-03-06
06/03/07 ①

Job Completion



U 06-03-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

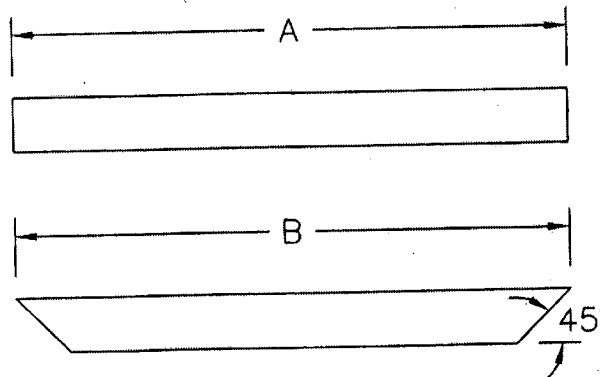


DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212) SCALE NTS	
A	95.11.21	NEW ISSUE	
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE	
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074	
D	01.04.19	CHANGE HINGE	
D1	UP 03.01.20	ADD D2012-117 FOR D130-701-041	
D2	UP 04.09.20	TACK WELD ANT-SKID AREA	

RELEASED
01.04.27 #

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



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WORK ORDER
NO. 25438B

D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

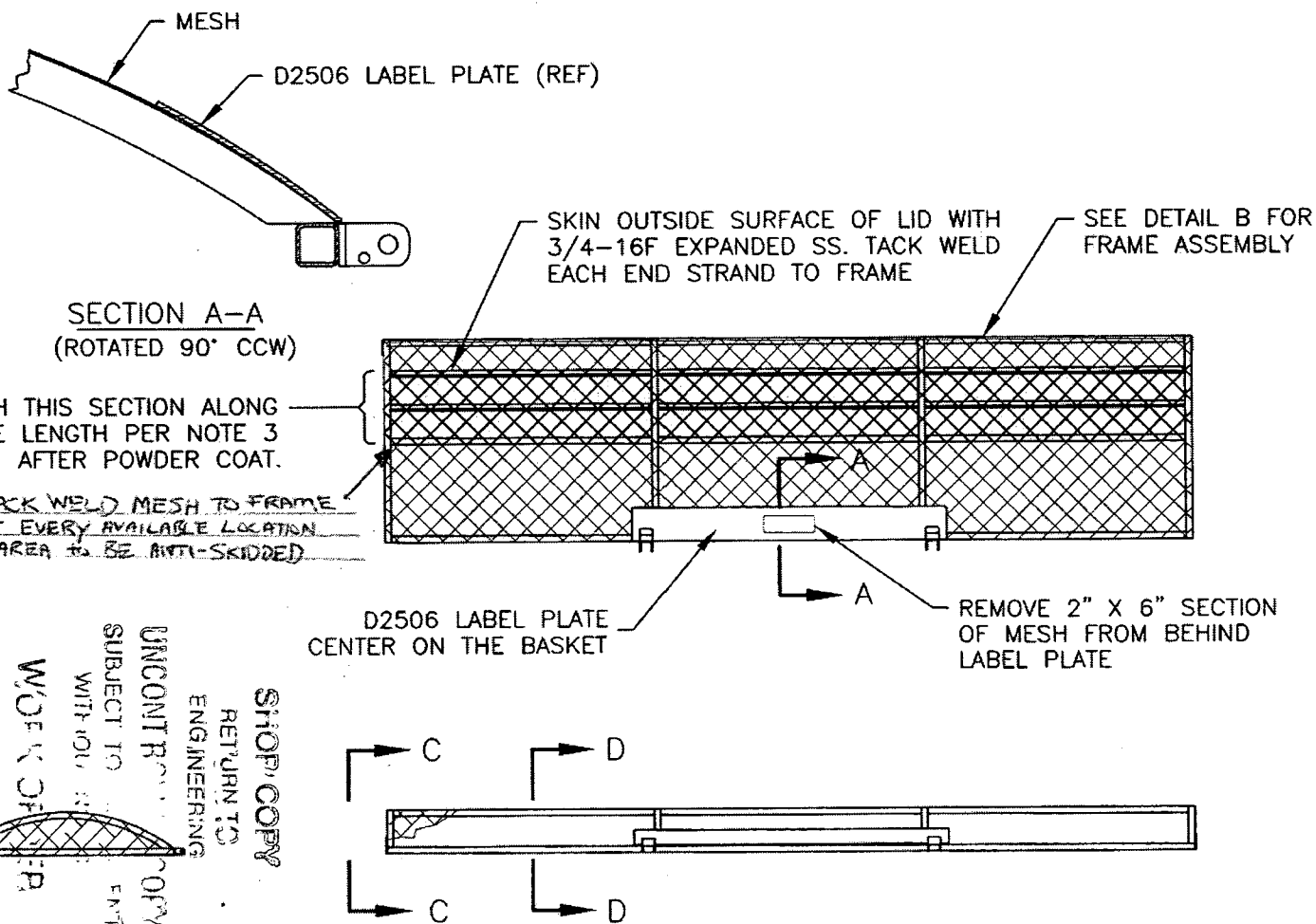
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	D2512
DATE	01.04.19	TITLE	BASKET LID ASSEMBLY (350/212)	REV. D	SHEET 2 OF 4
		SCALE	1:20		



D2512 BASKET LID ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

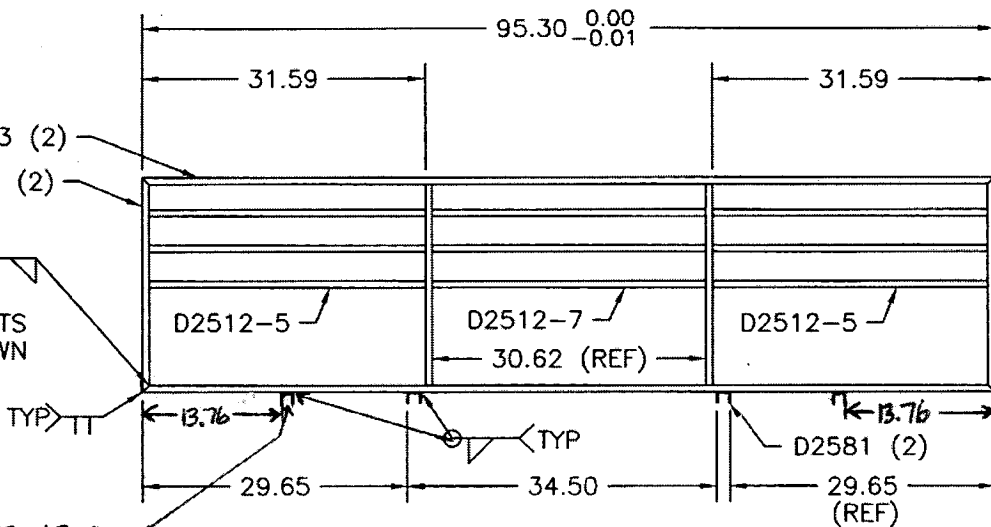
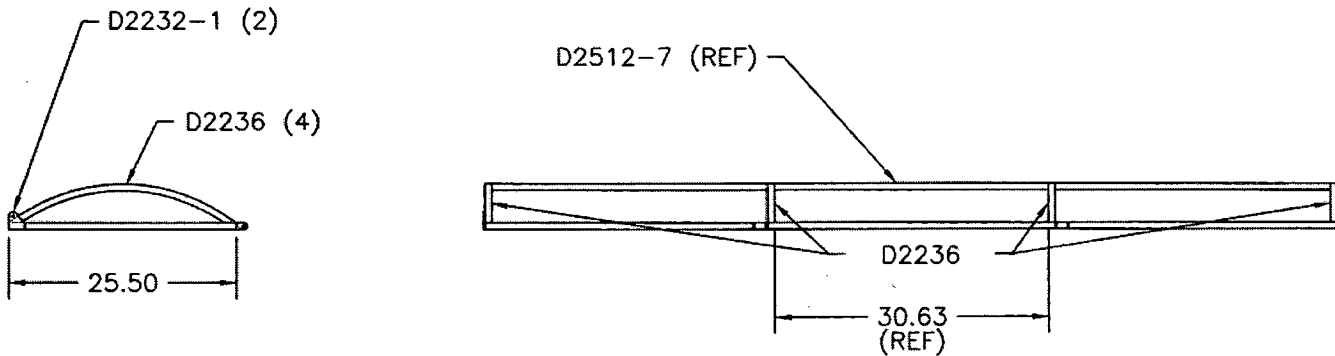
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BW	UP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D2512
DATE	TITLE	REV. D
01.04.19	BASKET LID ASSEMBLY (350/212)	SHEET 3 OF 4
		SCALE 1:20



D2512-117 CLEMS
 ADD FOR D130-701-041
 ONLY (2 PLACES)

DETAIL B
 FRAMEWORK SHOWN FOR CLARITY
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 ALL DIMENSIONS ARE IN INCHES

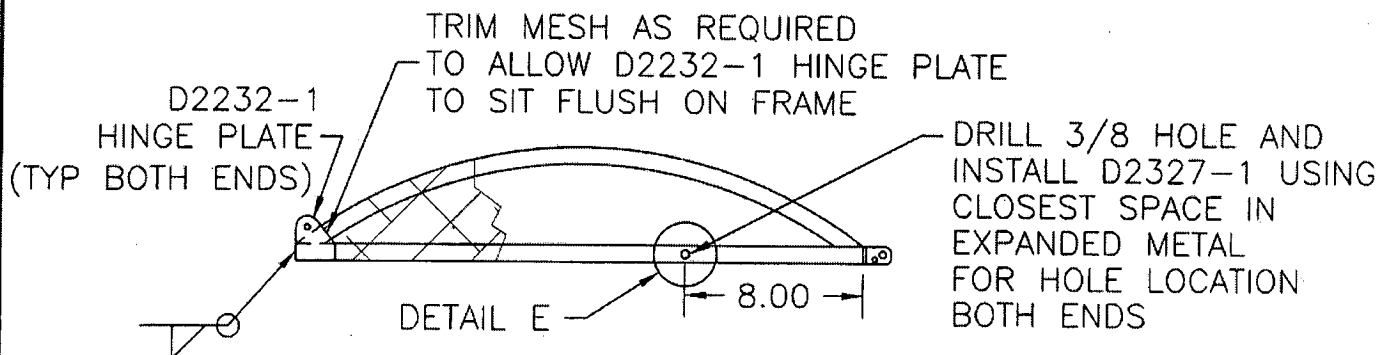
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 WITH NO
 ENGINE
 TYPE
 WELD
 JOINT
 ALL JOINTS
 AS SHOWN

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 01.04.27

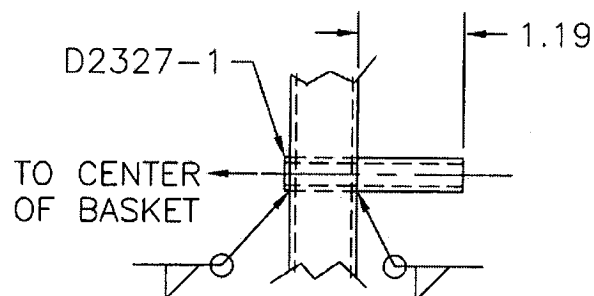
WORK ORDER
 NO 25438B



DESIGN BW	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8



SECTION C-C SIMILIAR BOTH END RIBS

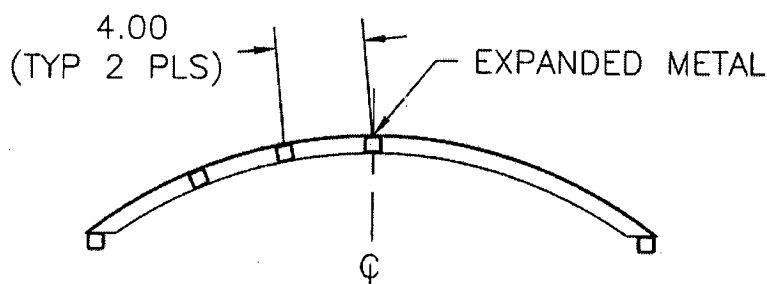


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WORK ORDER

NO. 25438B



SECTION D-D SAME BOTH CENTER RIBS

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01.04.27

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Date: Wednesday, 1/11/2006 4:17:38 PM
 User: Kim Johnston

Process Sheet

4

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HELI UTILITY BASKET LH/RH
 Job Number : 25438
 Estimate Number : 10197
 P.O. Number :
 This Issue : 1/11/2006 S.O. No. :
 Prsht Rev. : NC Part Number : D350607041
 First Issue : 11 Type : LARGE FAB ASSY Drawing Number : UNDER REVIEW D350-607 Rev. F
 Previous Run : 25436 Drawing Revision : F
 Material :
 Due Date : 1/26/2006 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:M 05.09.02 Added D2856-400-720 KJ/JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	25438A	BASKET BASE ASSEMBLY (350)



Comment: Sub-Component BASKET BASE ASSEMBLY (350)

2.0	25438B	350/212/130 BASKET LID
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Comment: Sub-Component 350/212/130 BASKET LID

3.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD350-607-041 CHG006

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

5.0	D2022101	Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
2	D2022-101	Spacer	

6.0	D2258200	Weight Placard 200lb
-----	----------	----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
1	D2258-200	Label	

REFERENCE ONLY